

Work Order ID 85199

85199

Page 1

June-04-12 1:34:12 PM

Item ID: D3324-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Base Assembly

Start Date: 04/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/04 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	4122760
4	D3324-3	Full Length Tube	4122760
2	D3324-5	Top End Tube	4122760
2	D3324-7	Bottom End Tube	4122760
10	D3324-9	Vertical Tube	4122760

2- Weld as per dwg

A/R 4130 rod batch: 4106075

1x DAS 43 13-11-08
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

① 13-11-03

DAS
9
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 18/06/2012 Req'd Qty: 1.00

1

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O

0.00

120

QC Memo

0.00

Quality Control

① 13-11-08 **DAS**
9
9-89

121 Pressure Wash per QSI005 4.3

0.00

121

HandFinish Memo

0.00

Hand Finishing

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Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 04/06/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 18/06/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

130

te Gloss(Ref:4.3.5.1) per
11/26/52

0.00

Powdercoat

Memo

Powder Coating

1ST COAT:

START TIME: 9:20

OVEN TEMPERATURE: 400

FINISH TIME: 0735

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

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Work Order ID 85199

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Page 4

June-04-12 1:34:12 PM

Item ID: D3324-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 04/06/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 18/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>wlo</u>	0.00		0350-721-041/1385196					
150		0.00							
Packaging	Memo								
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160		0.00							
QC	Memo								
Quality Control									

[Signature] / Rm 13/11/12.
MF
 13-11-11

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NOTE: Date & initial all entries

Picklist Print

June-04-12 1:34:17 PM

Page 1
12

Work Order ID: 85199

85199

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A05.02.09New issueKJ/JLM

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3 *D3328-3* Basket Hinge		Manufactured	No			100	Each	10.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		10							
				33872		10							
D3348-1 *D3348-1* Glevis		Manufactured	No			100	Each	36.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		36							
				74727		36							
D3349-3 *D3349-3* Spacer Bushing		Manufactured	No			100	Each	16.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		16							
				75620		16							
D3367-1 *D3367-1* Mounting Bracket		Manufactured	No			100	Each	7.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		7							
				76500		7							

2
 DAS 43 12-10-04
 8-89
 2x
 4
 DAS 43 13-11-04
 8-89
 4x
 2
 DAS 43 B75620 → 2x
 8-89
 13-11-04
 2
 2
 2
 DAS 43 13-11-04
 8-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

June-04-12 1:34:17 PM

Page 2

Work Order ID: 85199

85199

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

240.7376

46.6

49.05263

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

4122760 → 52'

Location

Loc Qty

Loc Code

MAT034

240.7376

109127

39.5367

109385

15.75

112786

17.6261

119441

8.8248

119506

36.34

119683

122.66

DAS
43 13-10-08
8-09

M569EX0.50-18F

Purchased

No

100

sf

86.0000

28

28

M569EX0 50-18F

569 Expanded Metal

**

4123293 DAS
43 13-11-08
8-09

Location

Loc Qty

Loc Code

MAT018

36

120204

36

MAT019

50

112776

10

117806

4

119226

4

119404

32

June-04-12 1:34:17 PM

Shop Packet Print

Page 2

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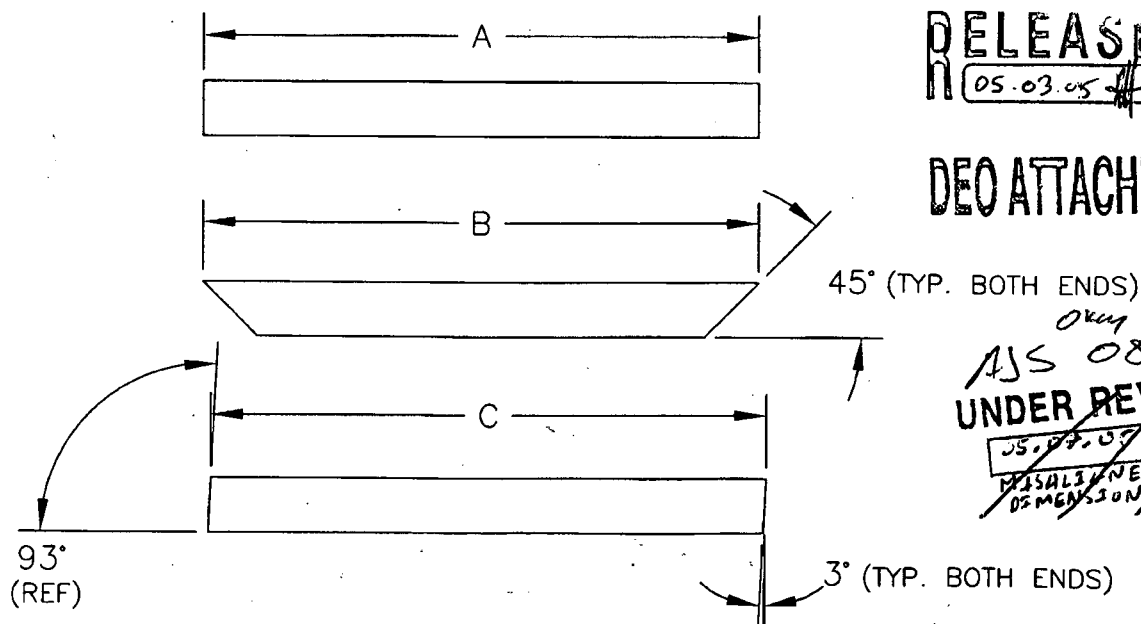
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05

DEO ATTACHED

UNDER REVIEW

05.03.05 PH
MISALIGNED
DIMENSION P6a

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 85199 MCB
12/09/00

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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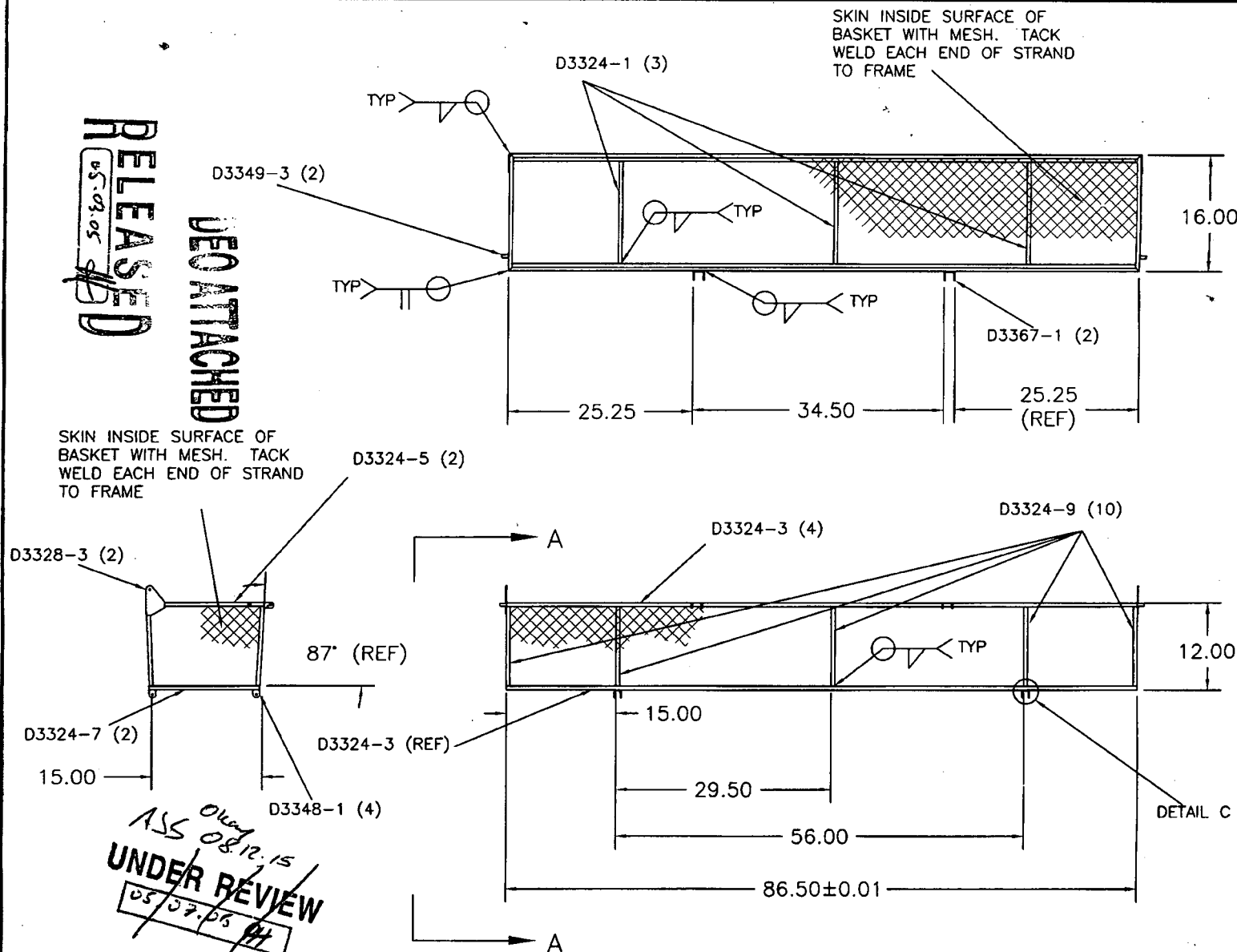
NOTE: Date & initial all entries

85199

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.03.04	DRAWING NO.	D3324	REV. B
TITLE	BASKET BASE ASSEMBLY	SHEET 2 OF 3	SCALE	1:20

SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

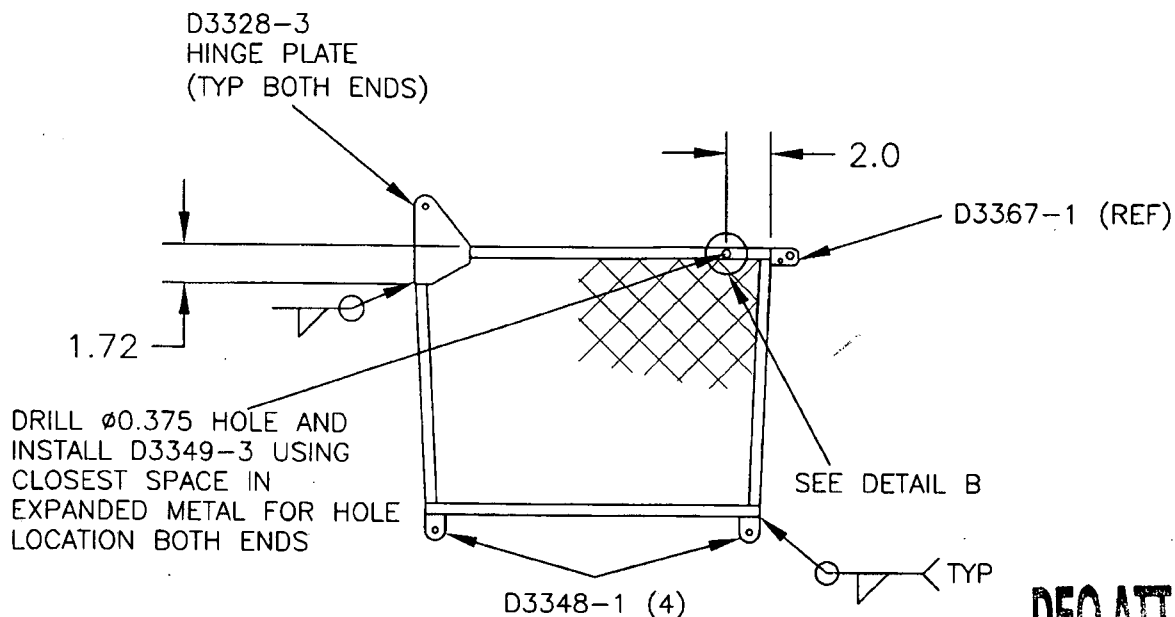
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NOTE: Date & initial all entries

95195



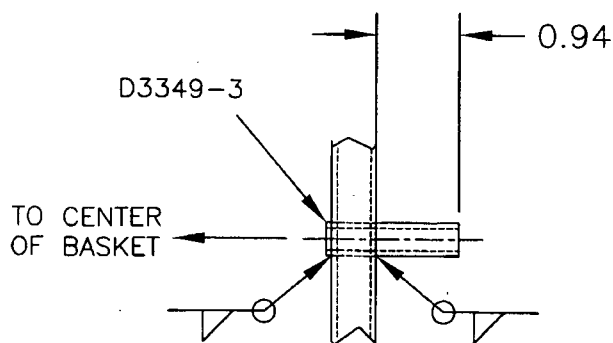
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



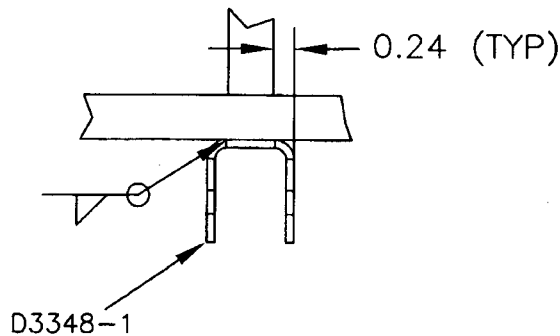
VIEW A-A

DEO ATTACHED

RELEASED
05.03.05



DETAIL B
(SCALE 1:2)



DETAIL C
(SCALE 1:2)

OK
155 08.12.15
UNDER REVIEW
05.07.06

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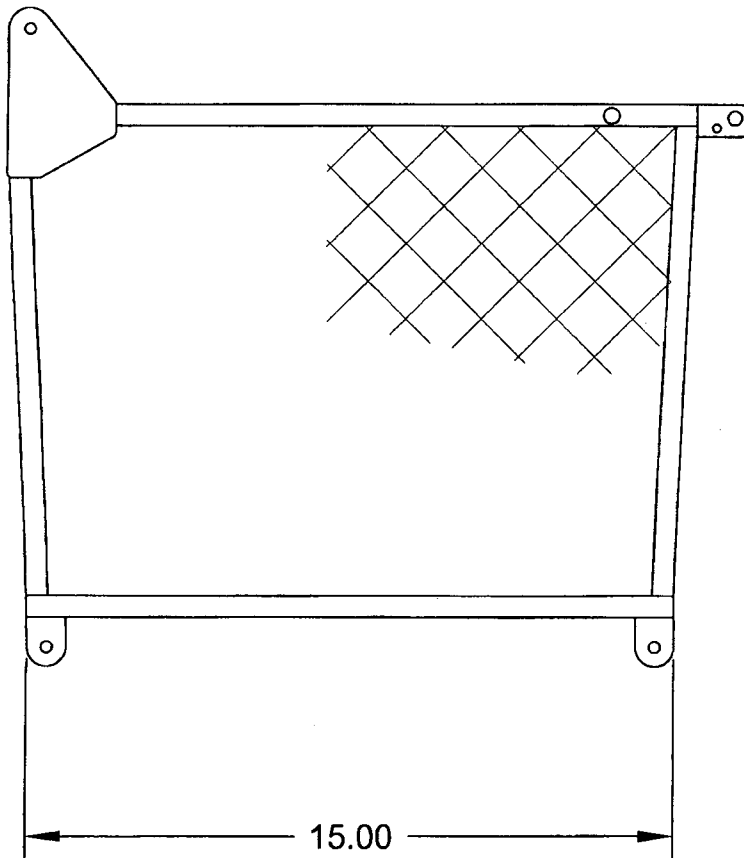
NOTE: Date & initial all entries

DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

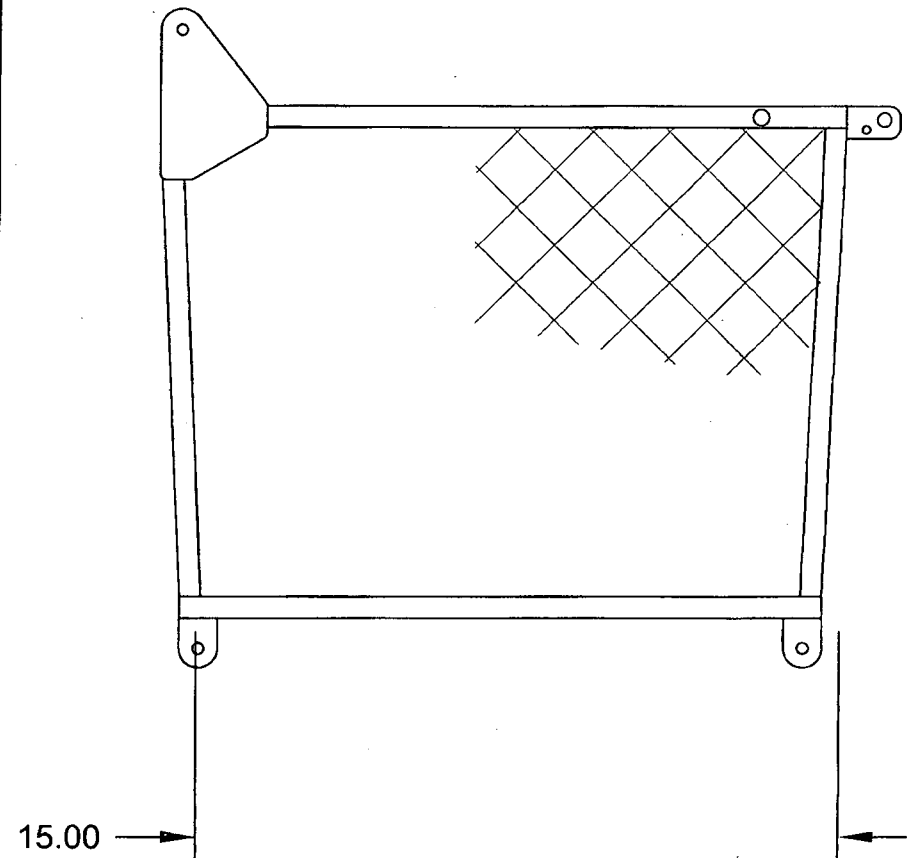
SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

85199

IS:



WAS:



W/O:		WORK ORDER CHANGES					
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